

Work Order ID 85270

85270

Page 1

June-05-12 10:52:52 AM

Item ID: D3784-044

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Seat Support Assembly, RH

Stop ***NS2***

Start Date: 05/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 19/06/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/05 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3784

Rev B

100

Pick Kit

0.00

100

Packaging

Memo

0.00

Packaging

4 0 FF
13-02-21

110

Small Fab

0.00

110

Small Fab

Memo

0.00

Small Fab

1-assemble as per dwg D3784****Note 8: Hole "A" is located 5" from the end of D3770-3 tube and must be oriented down*****Note 8: Hole "B" is located 5" from the end of D3770-1 tube and must be oriented forward****

4 0 FF
13-02-21

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

DAS
15
13-02-21

4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Seat Support Assembly, RH

Start Date: 05/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 19/06/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: ST-248

0.00

130

256

Packaging

Memo

0.00

Packaging

4

13-02-22 JB

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

13/2/25 JB

13-02-22

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Picklist Print

June-05-12 10:52:56 AM

Page 1

Work Order ID: 85270

85270

Parent Item: D3784-044

D3784-044

Parent Item Name: Seat Support Assembly, RH

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-05-19 new issue DD verified by:ec
IPP Rev:B 08-07-18 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN525-10R20		Purchased	No			110	Each	71.0000	4	16			

AN525-10R20

Screw

**

FF 13-02-21

Location	Loc Qty	Loc Code
ST345 124215	50	
121011	50	
ST346	21	
114348	3	
114354	18	

3
13

AN960JD10L NAS1149D0332J Purchased No

AN960JD10L

Washer

D3763-041 Manufactured No

D3763-041

End Fitting Assembly

**

16

FF 13-02-21

Location	Loc Qty	Loc Code
ST243 85950	6	
79096	6	

8

D3763-044 Manufactured No

D3763-044

End Fitting Assembly, RH

**

8

FF 13-02-21

Location	Loc Qty	Loc Code
ST243 79349	1	
81637	1	

3

1

FF 13-02-21

87437

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

June-05-12 10:52:56 AM

Page 2

Work Order ID: 85270

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Parent Item: D3784-044

D3784-044

Parent Item Name: Seat Support Assembly, RH

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 4.00

Required Qty: 4.00

D3770-1 Manufactured No

110 Each 3.0000 1 4

D3770-1

Tube

**

FF 13-02-21

Location

Loc Qty

Loc Code

ST248

87705

3

3

65060

3

1

D3770-3 Manufactured No

110 Each 5.0000 1 4

D3770-3

Tube

**

FF 13-02-21

Location

Loc Qty

Loc Code

ST250

86130

3

1

65061

3

3

ST254

2

54318

2

MS21042L3 Purchased No

110 Each 2,161.000 4 16

MS21042L3

Nut

**

FF 13-02-21

Location

Loc Qty

Loc Code

ST300

123900

2161

16

115835

4

117885

32

119017

952

119075

138

121349

215

121444

820

June-05-12 10:52:56 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

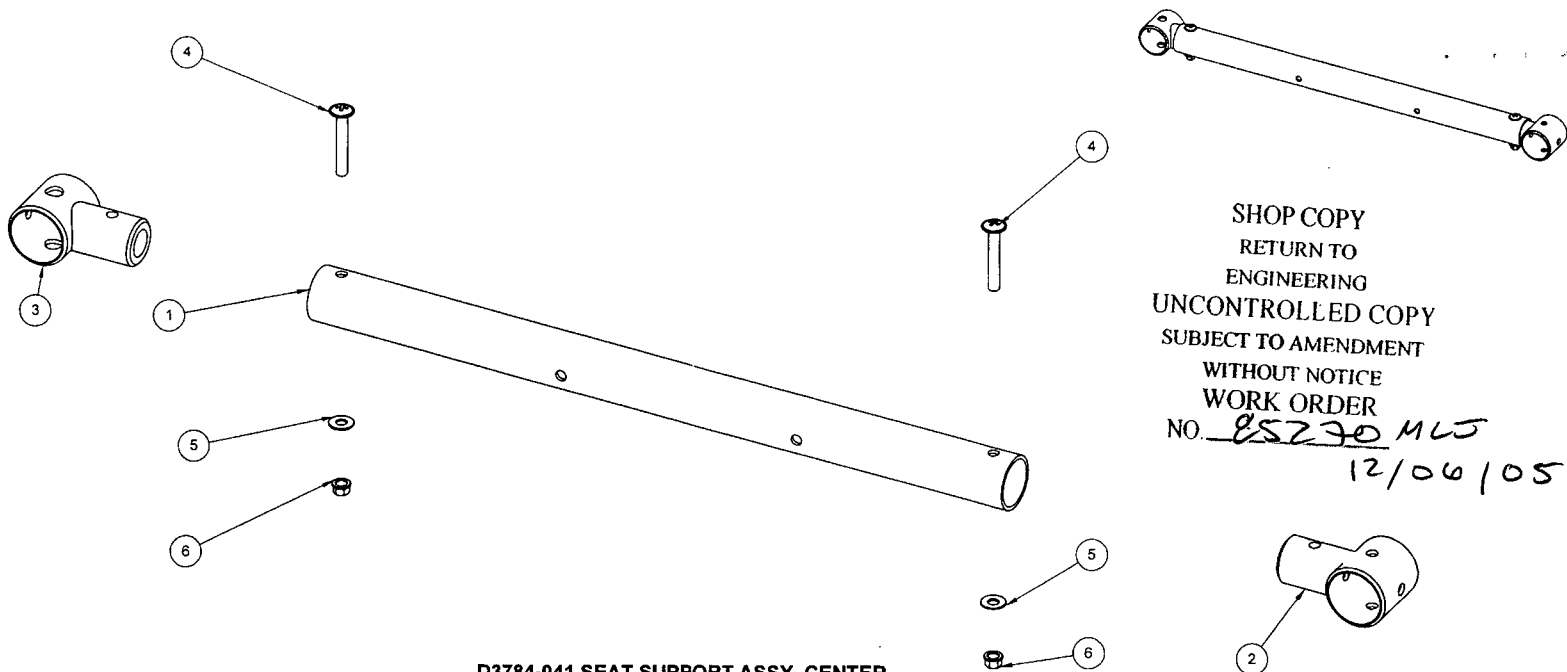
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85270 M/L
12/06/05

D3784-041 SEAT SUPPORT ASSY, CENTER

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3770-1	TUBE	1
2	D3763-041	END FITTING ASSY	1
3	D3763-045	END FITTING ASSY	1
4	AN525-10R20	SCREW	2
5	NAS1149D0332J	WASHER (AN960JD10L)	2
6	MS21042L3	NUT	2

△
B
△
B
△
B
△
B

85270 M/L

- NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.31 lbs

B	HARDWARE CHANGE, ASSY CHANGE	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS	DRAWING NO. D3784 REV. B	
CHECKED	HS	SHEET 1 OF 5	
MFG. APPR.	HS	TITLE SEAT SUPPORT ASSEMBLY SCALE NTS	
APPROVED	HS	DATE 08.06.23	
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

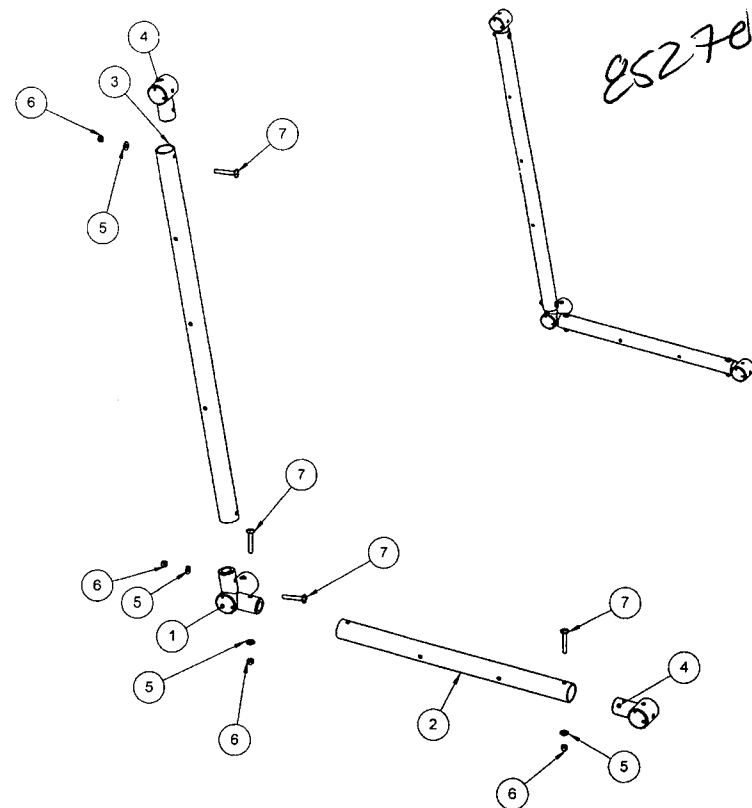
ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3763-043	END FITTING ASSY, LH	1
2	D3770-1	TUBE	1
3	D3770-3	TUBE	1
4	D3763-041	END FITTING ASSY	2
5	NAS1149D0332J	WASHER (AN960JD10L)	4
6	MS21042L3	NUT	4
7	AN525-10R20	SCREW	4

D3784-043 SEAT SUPPORT ASSY, LH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.78 lbs

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	HS	
CHECKED	PA	DRAWING NO. D3784
MFG. APPR.	MA	REV. B SHEET 2 OF 5
APPROVED	MA	TITLE SEAT SUPPORT ASSEMBLY
DE APPR.	MA	SCALE NTS
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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

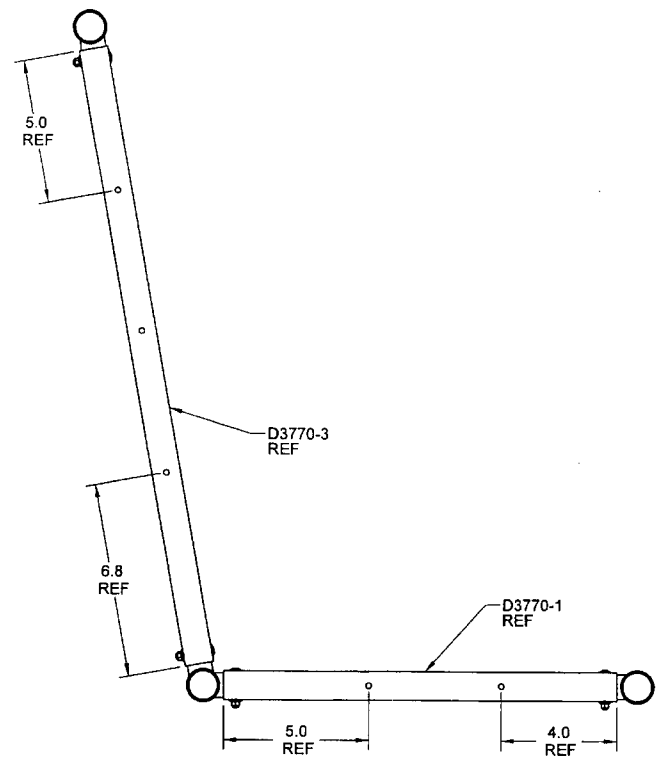
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

25270



D3784-043 SEAT SUPPORT ASSY, LH

08.07.10 JHP

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BS	DRAWING NO.	REV. B
MFG. APPR.	AP	D3784	SHEET 3 OF 5
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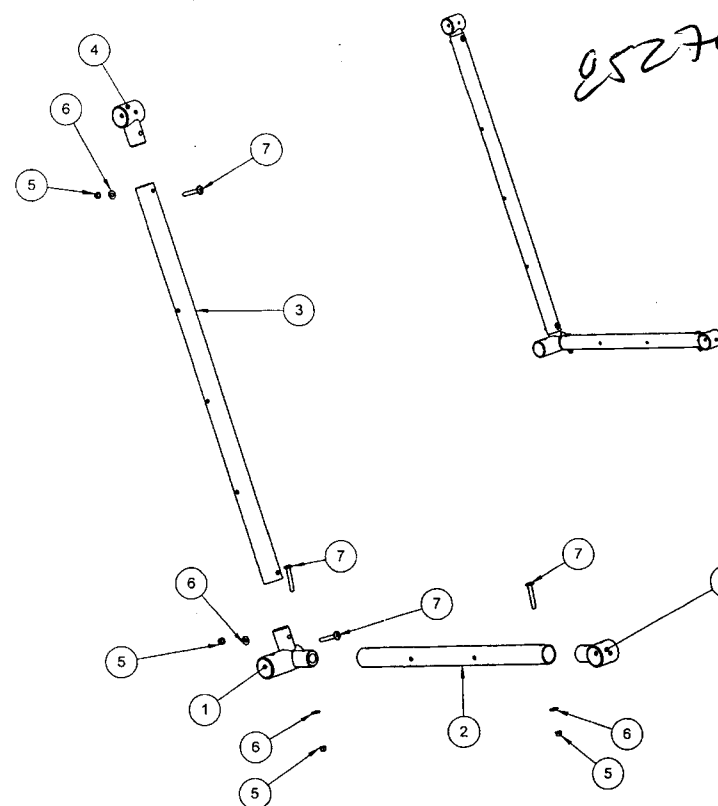
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ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3763-044	END FITTING ASSY, RH	1
2	D3770-1	TUBE	1
3	D3770-3	TUBE	1
4	D3763-041	END FITTING ASSY	2
5	MS21042L3	NUT	4
6	NAS1149D0332J	WASHER (AN960JD10L)	4
7	AN525-10R20	SCREW	4

B
 B
 B



D3784-044 SEAT SUPPORT ASSY, RH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.78 lbs

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DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	D3784	SHEET 4 OF 5
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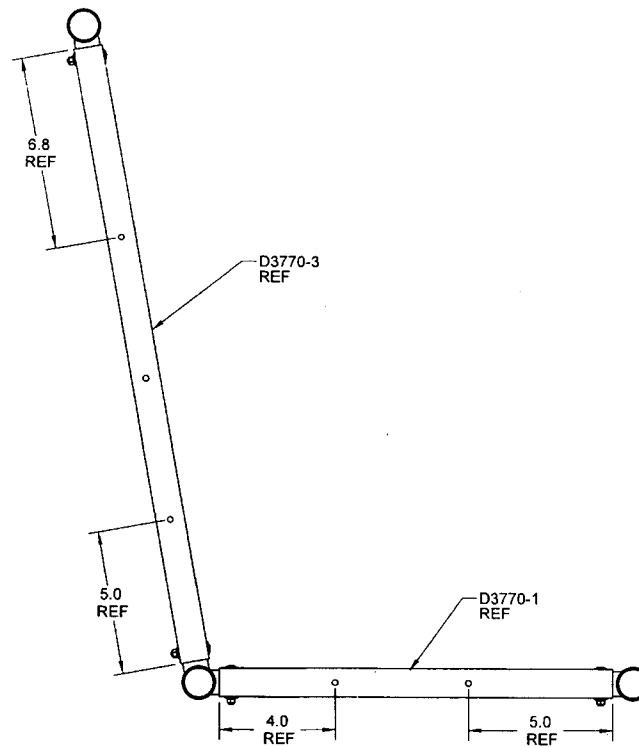
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2527e



D3784-044 SEAT SUPPORT ASSY, RH

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DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	D3784	SHEET 5 OF 5
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DE APPR.	HS	SEAT SUPPORT ASSEMBLY	NTS
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